US009164429B2

(12) **United States Patent**
Xu

(10) **Patent No.: US 9,164,429 B2**
(45) **Date of Patent: Oct. 20, 2015**

(54) **DEVELOPING DEVICE CAPABLE OF RESTRAINING LEAKAGE OF DEVELOPING AGENT**

(71) Applicant: **Brother Kogyo Kabushiki Kaisha**, Nagoya-shi, Aichi-ken (JP)

(72) Inventor: **Fan Xu**, Nagoya (JP)

(73) Assignee: **Brother Kogyo Kabushiki Kaisha**, Nagoya-shi, Aichi-ken (JP)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **14/316,838**

(22) Filed: **Jun. 27, 2014**

(65) **Prior Publication Data**

US 2015/0003863 A1 Jan. 1, 2015

(30) **Foreign Application Priority Data**

Jun. 28, 2013 (JP) 2013-137424

(51) **Int. Cl.**
G03G 15/08 (2006.01)

(52) **U.S. Cl.**
CPC ***G03G 15/0881*** (2013.01)

(58) **Field of Classification Search**
CPC G03G 15/0817; G03G 15/0881; G03G 15/0898
USPC 399/103
See application file for complete search history.

(56) **References Cited**

U.S. PATENT DOCUMENTS

5,701,558	A	12/1997	Kojima	
7,630,666	B2 *	12/2009	Nakaya et al.	399/103
8,229,317	B2 *	7/2012	Xu et al.	399/105
8,620,177	B2 *	12/2013	Carot	399/103
8,712,296	B2	4/2014	Mori	
8,855,526	B2 *	10/2014	Ito et al.	399/103
2011/0158708	A1	6/2011	Mori	

FOREIGN PATENT DOCUMENTS

JP	H07-146613	A	6/1995
JP	2009-244450	A	10/2009
JP	2011-150269	A	8/2011

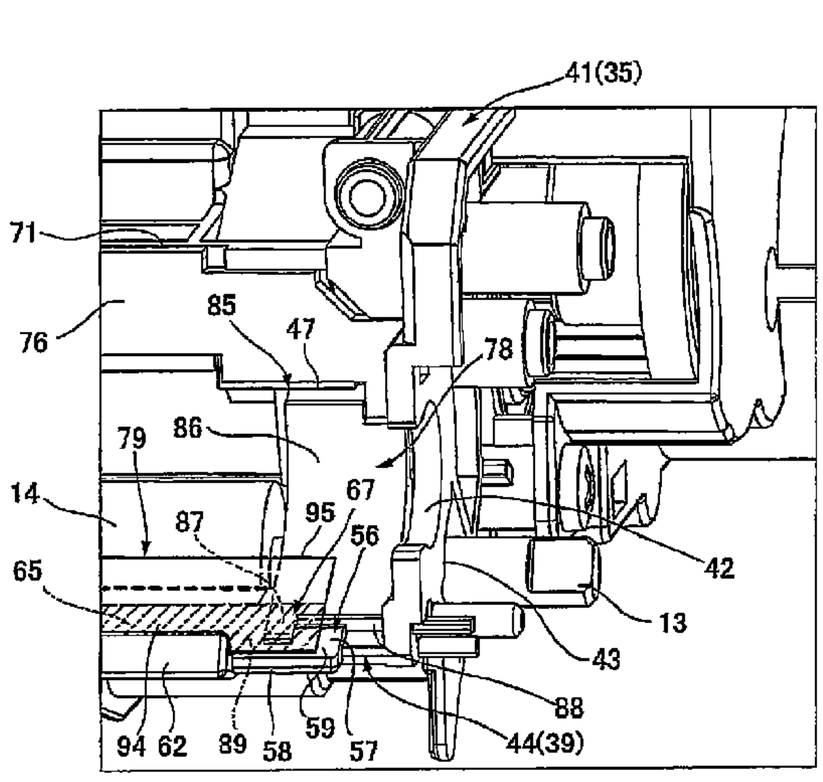
* cited by examiner

Primary Examiner — William J Royer
(74) *Attorney, Agent, or Firm* — Banner & Witcoff, Ltd.

(57) **ABSTRACT**

A developing device includes a frame, a developing roller, and first and second seals. The frame has a seal adhesion surface and a seal placement portion. The first seal is provided between the frame and a peripheral surface at an end portion of the developing roller. The second seal is in contact with the peripheral surface and has an end region positioned between the first seal and the peripheral surface. The second seal has a first end portion and a second end portion. The first end portion is adhered to the seal adhesion surface and has an end part adhered onto the first seal. The second end portion is in contact with the peripheral surface of the developing roller. The first seal is compressed in the seal placement portion by the second seal to abut on a stepped portion of the seal placement portion.

8 Claims, 7 Drawing Sheets



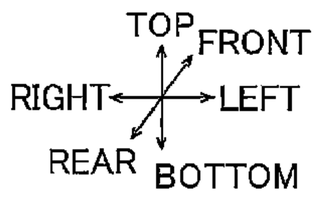
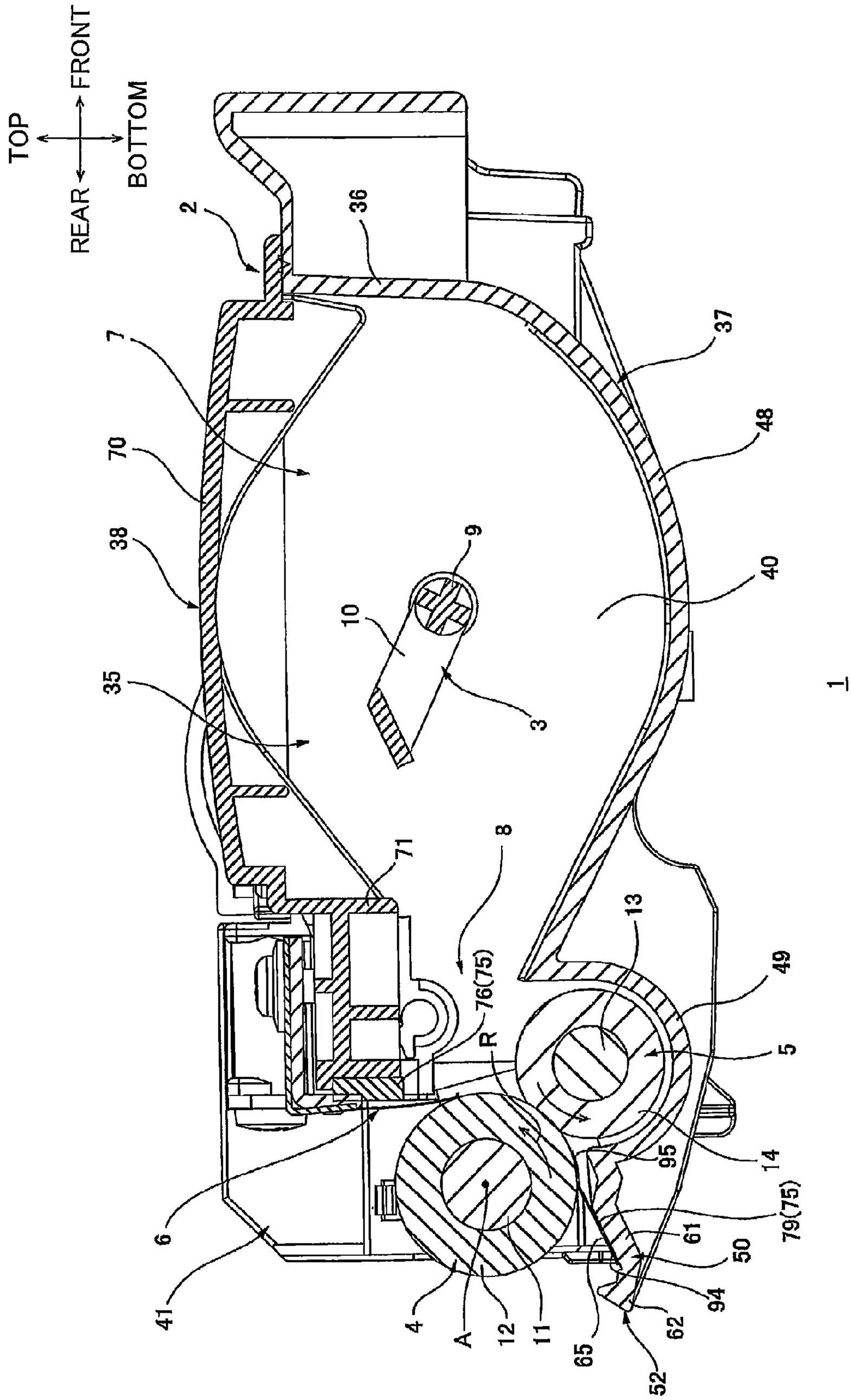


FIG.1


TOP
FRONT
REAR
BOTTOM
2
36
7
70
38
35
9
10
3
37
48
40
1
8
71
13
76(75)
R
49
5
95
14
79(75)
61
50
94
62
52
65
11
12
A
4
41
6

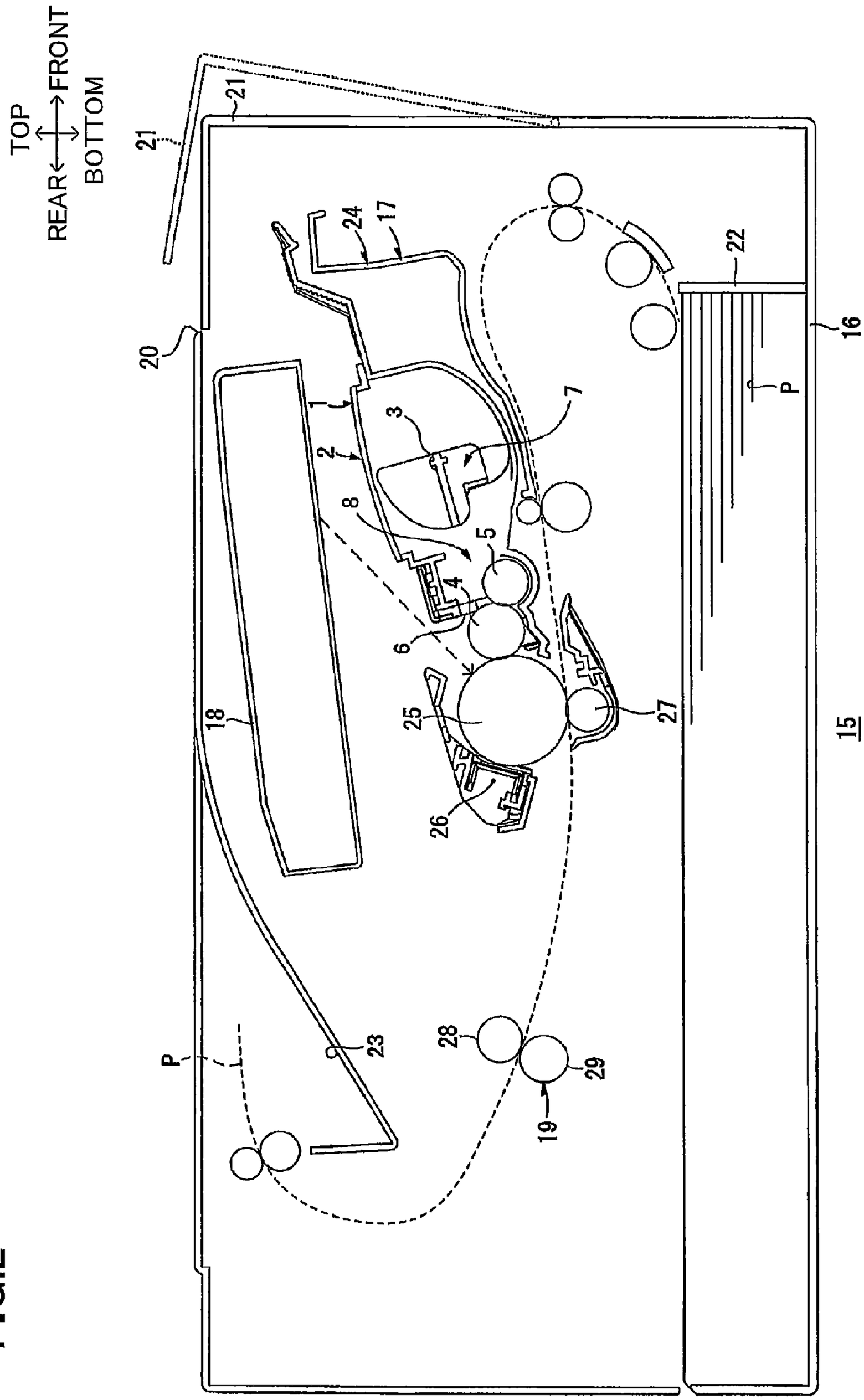

TOP
REAR
FRONT
BOTTOM
21
21
24
17
22
20
1
2
3
7
8
5
4
6
16
P
18
25
27
26
15
23
28
29
19
P

FIG.2

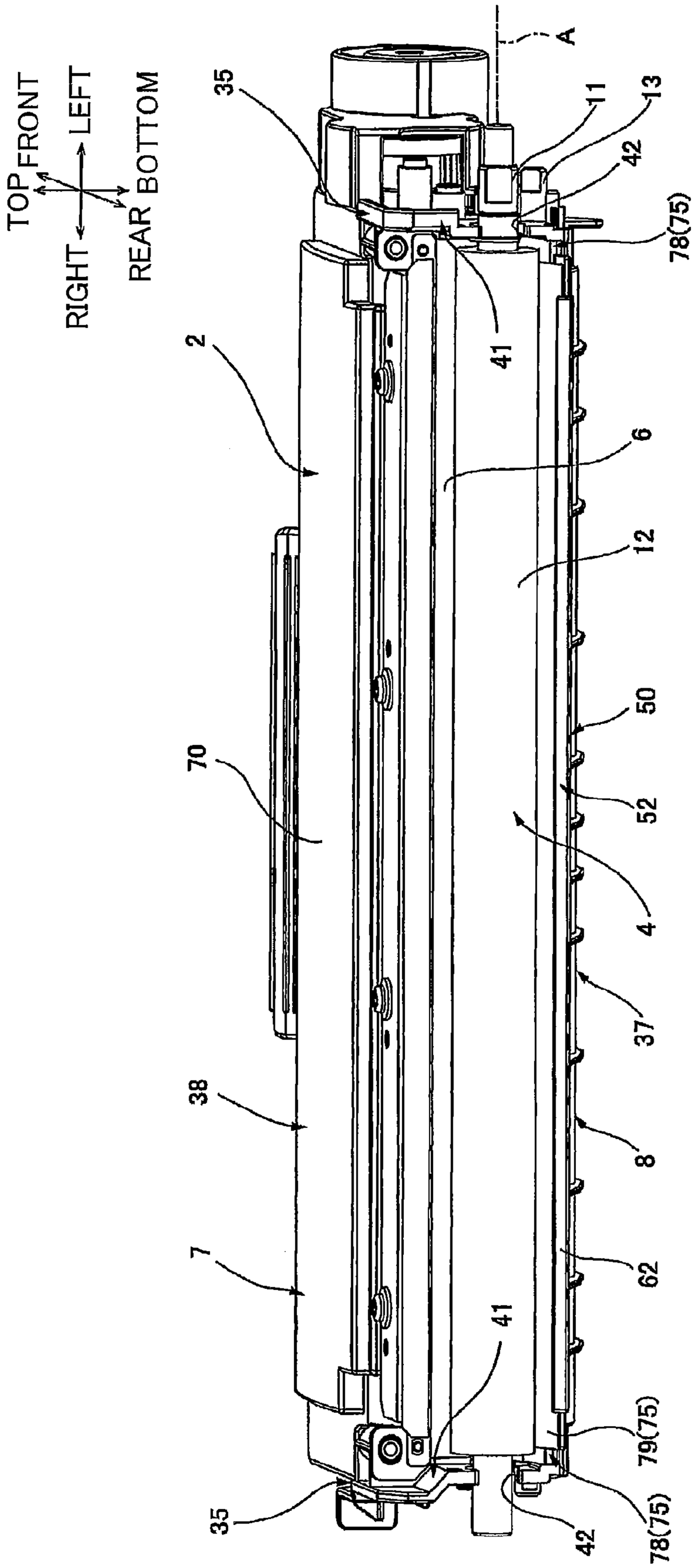

TOP
FRONT
LEFT
RIGHT
REAR
BOTTOM
A
35
11
13
42
78(75)
41
2
6
12
50
70
52
4
37
38
8
7
62
41
79(75)
78(75)
42
1

FIG.3

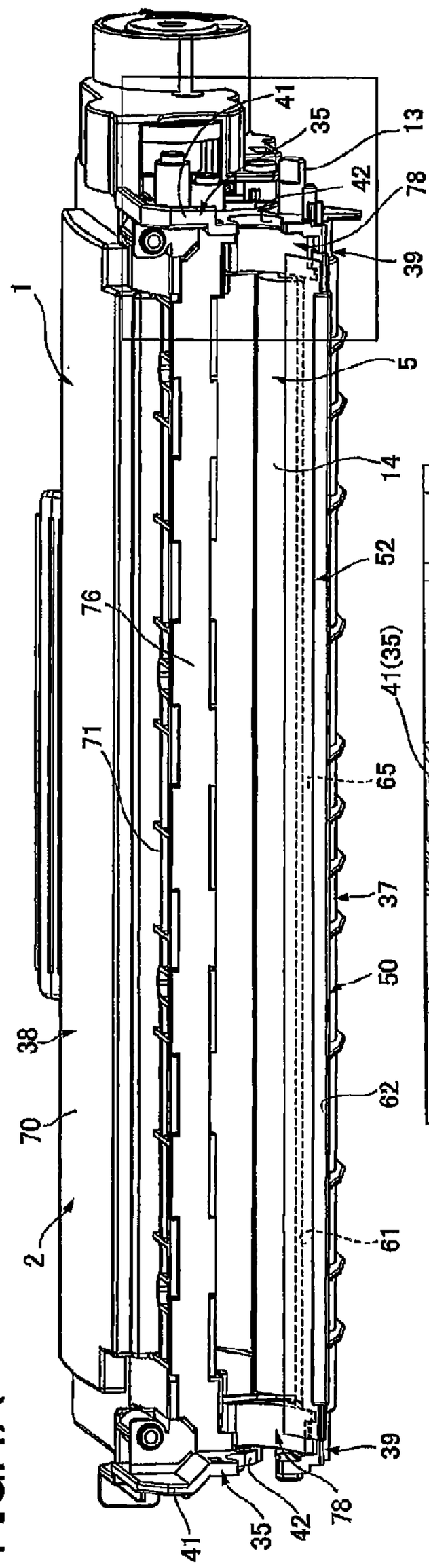
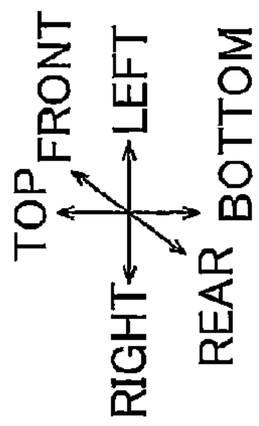

1
2
5
14
52
76
71
65
37
50
38
62
70
61
39
41
35
42
78
13

FIG.4A


TOP
FRONT
LEFT
RIGHT
REAR
BOTTOM

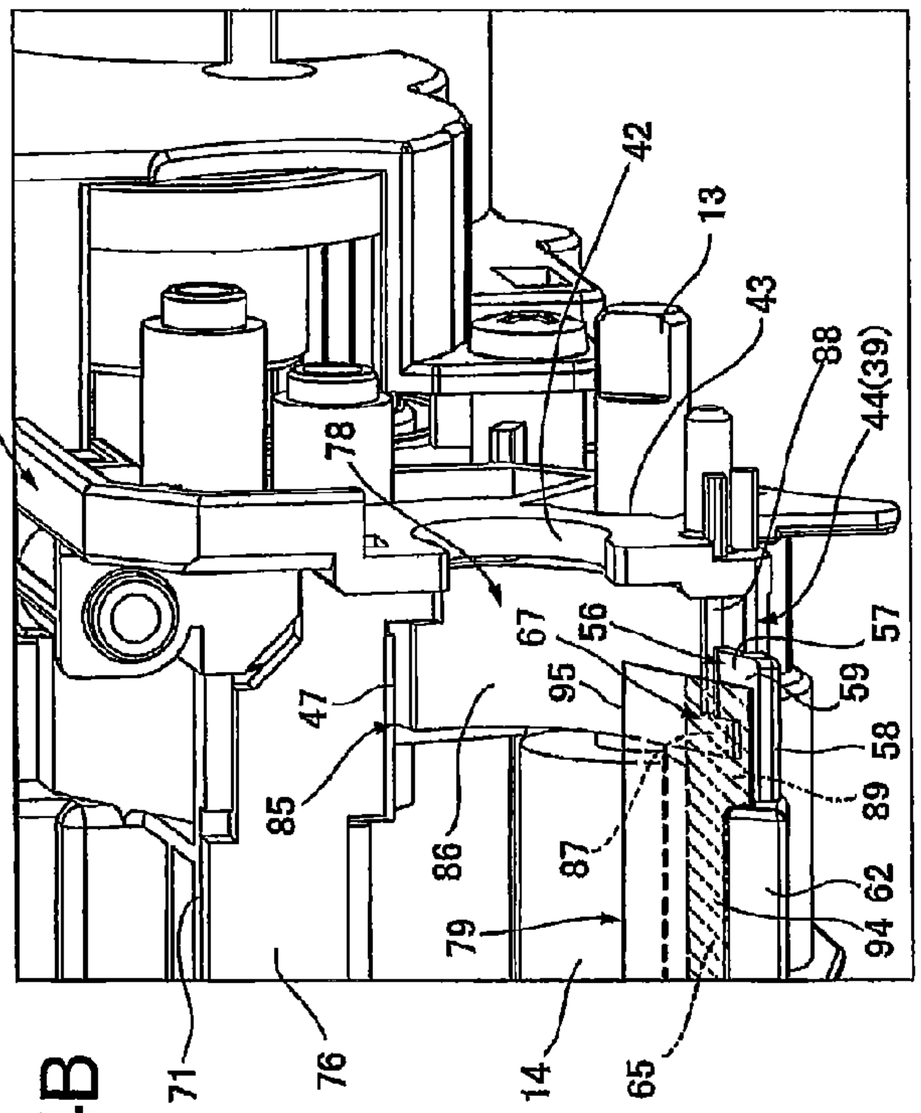

41(35)
42
13
43
88
44(39)
78
67
56
57
59
95
47
58
89
85
86
87
62
94
79
71
76
14
65

FIG.4B

FIG.5B

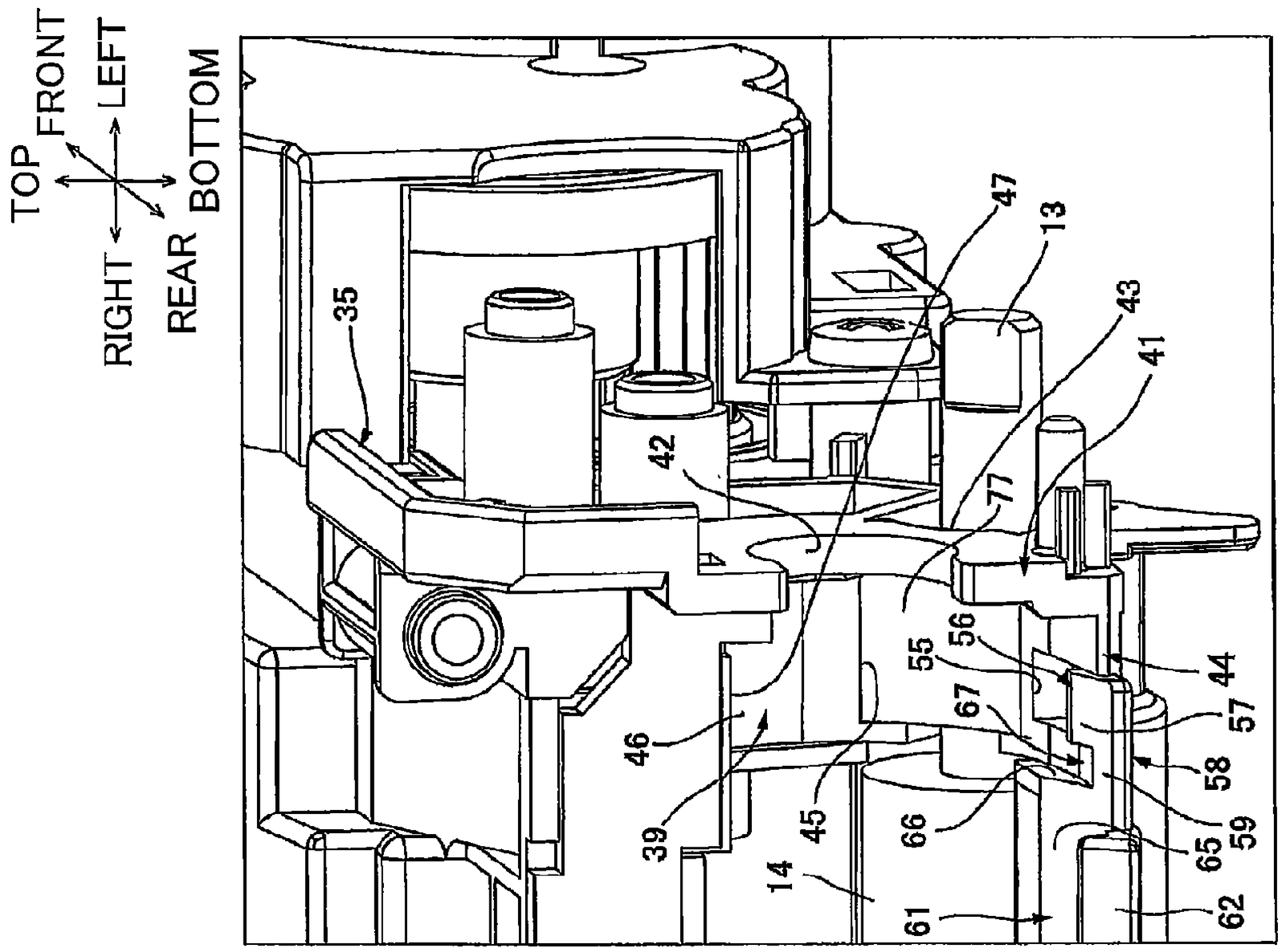

TOP
FRONT
LEFT
RIGHT
REAR
BOTTOM
35
42
46
39
45
14
61
66
67
55
56
47
13
43
41
77
44
57
58
65
59
62

FIG.5A

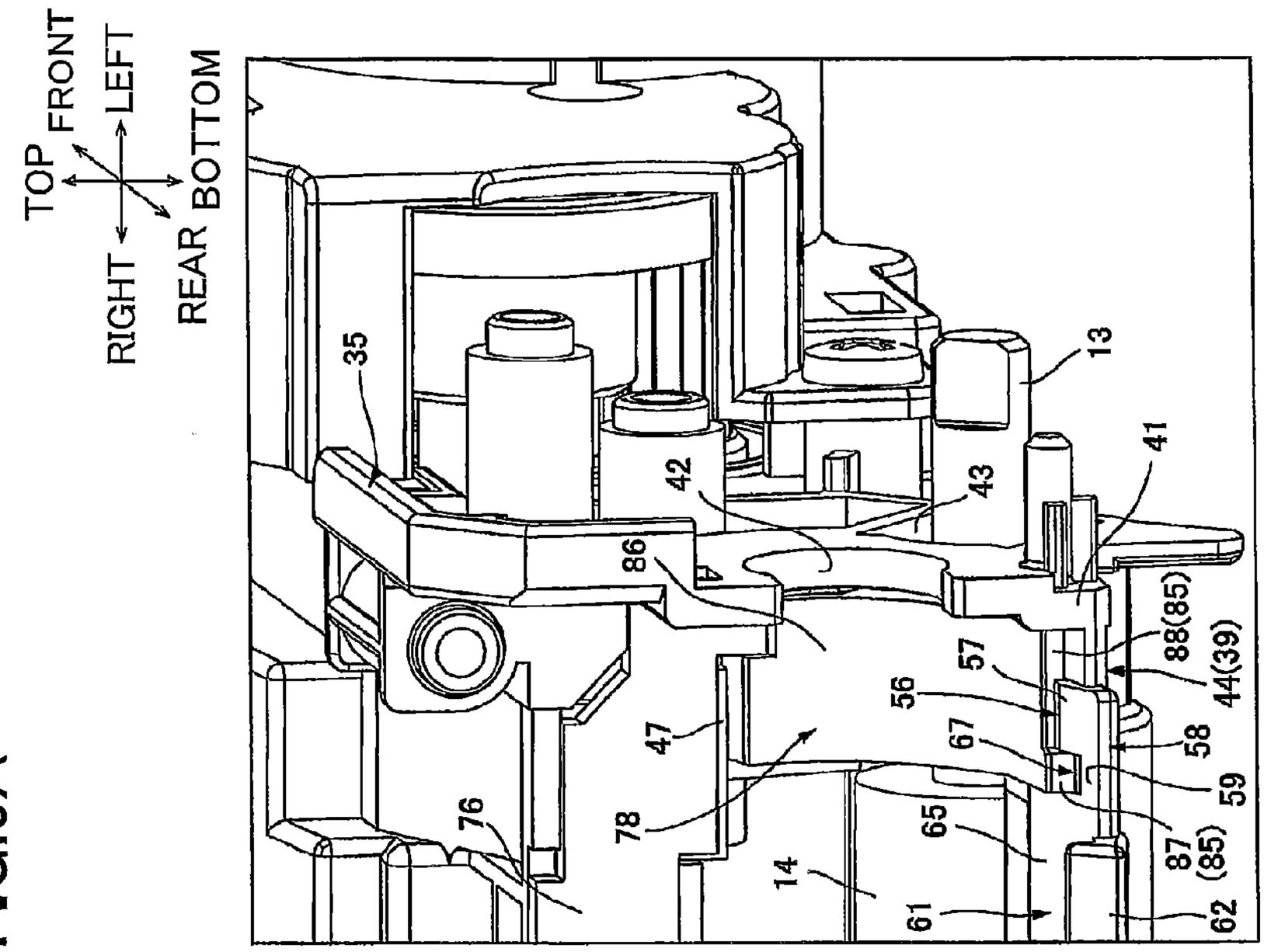

TOP
FRONT
LEFT
RIGHT
REAR
BOTTOM
35
42
86
47
78
76
14
61
65
67
56
57
58
59
87
(85)
62
88(85)
44(39)
43
41
13

FIG.6C

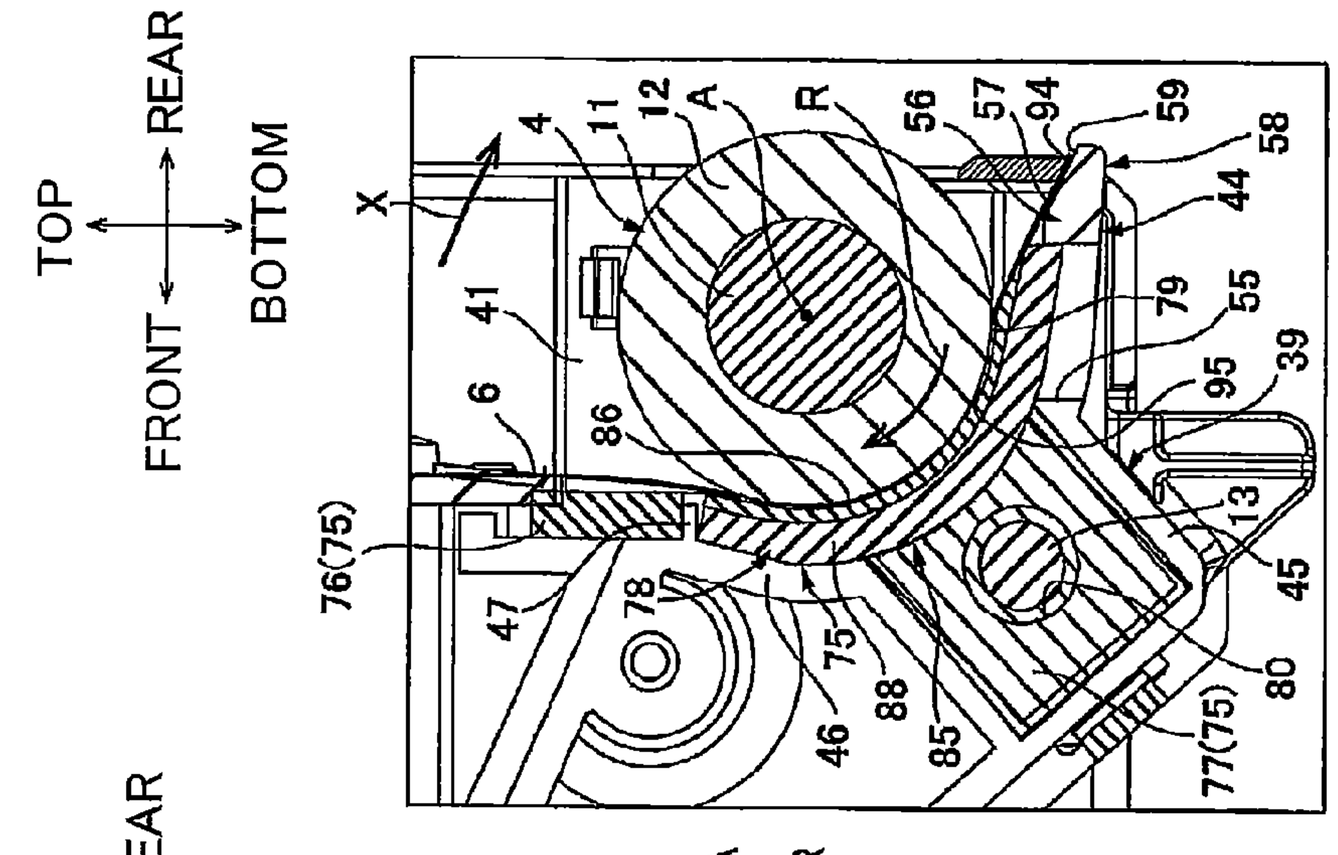


FIG.6B

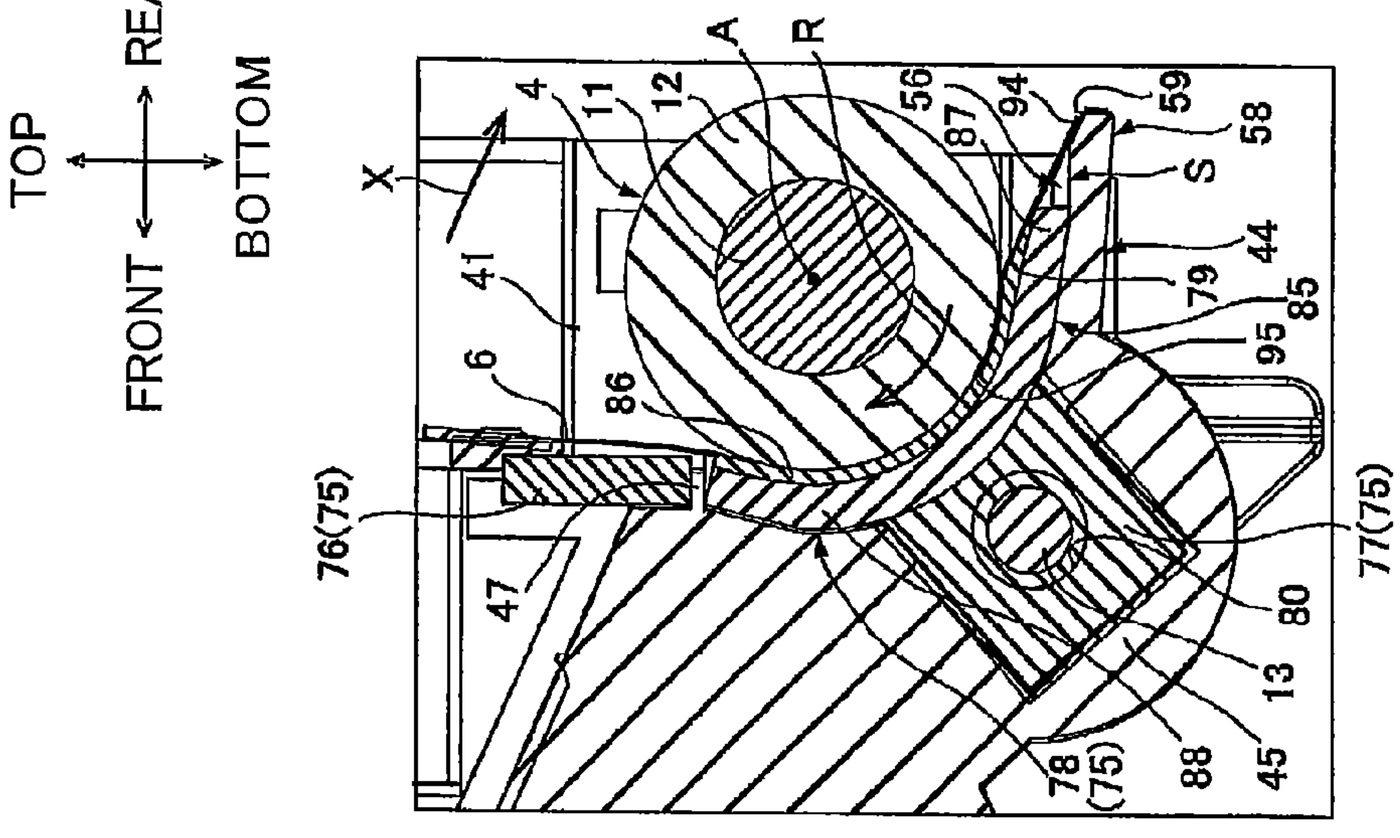


FIG.6A

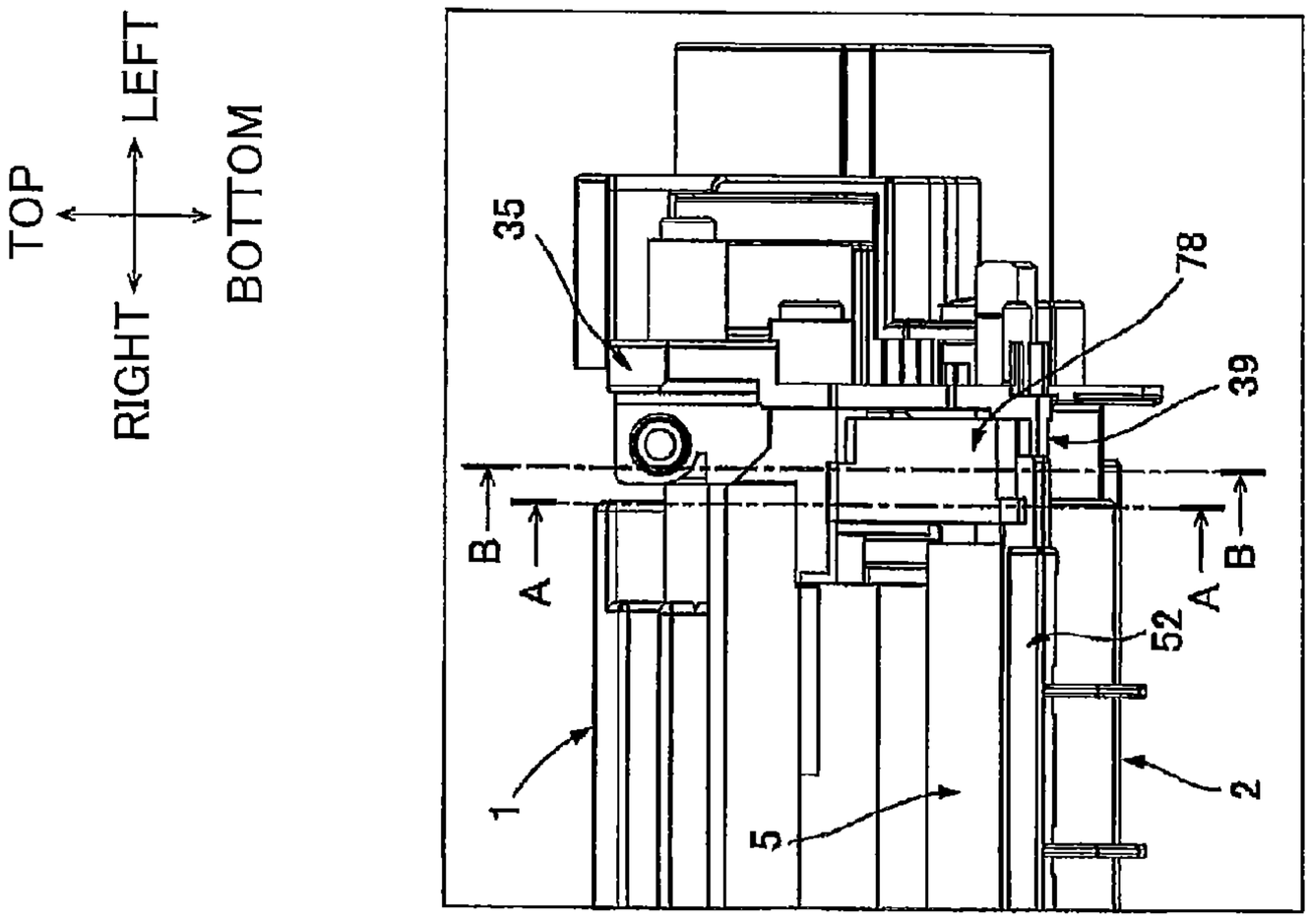
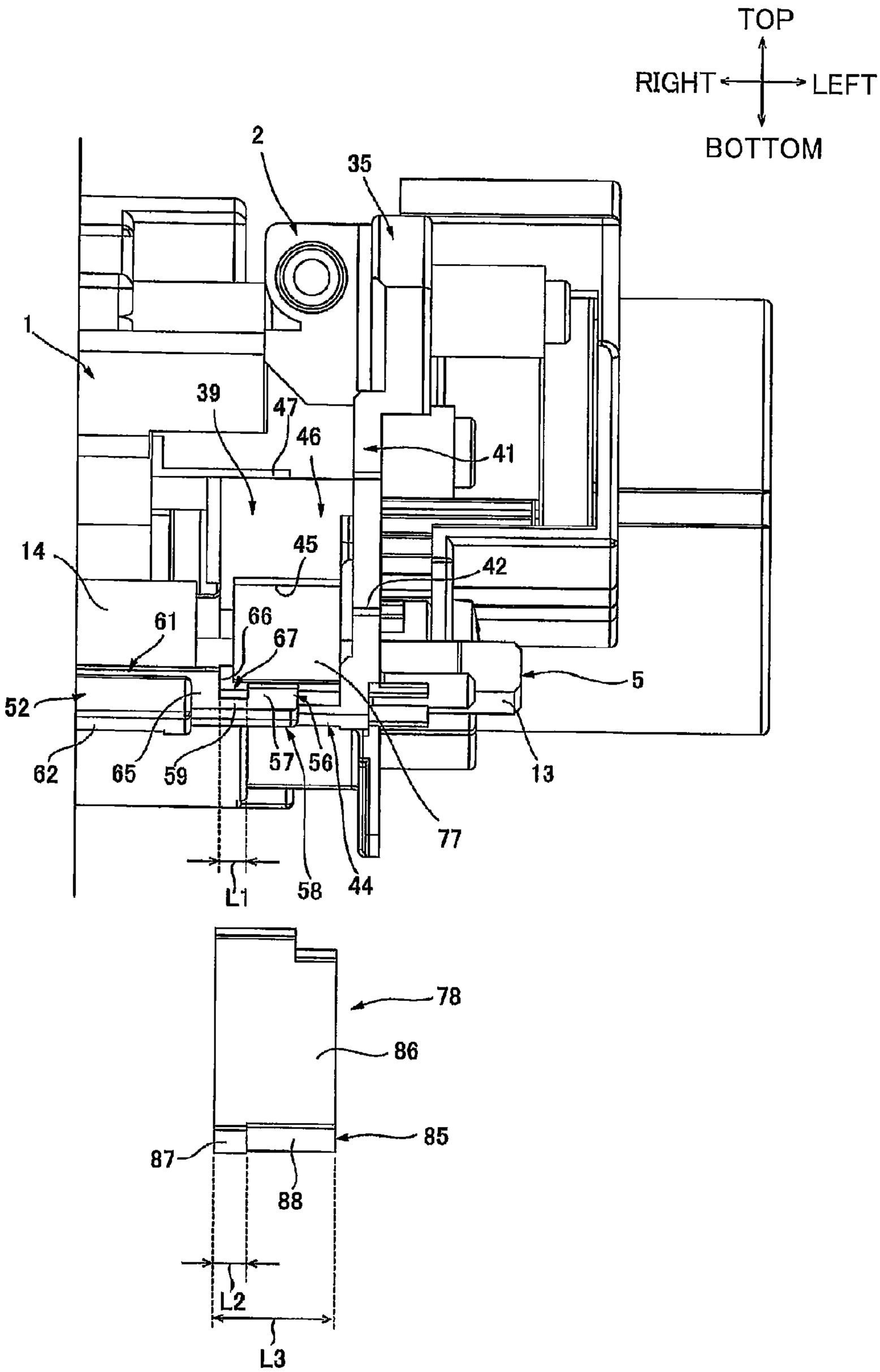


FIG.7


TOP
RIGHT
LEFT
BOTTOM
2
35
1
39
47
46
41
14
45
42
61
66
67
5
52
62
65
59
57
56
13
77
L1
58
44
78
86
85
87
88
L2
L3

DEVELOPING DEVICE CAPABLE OF RESTRAINING LEAKAGE OF DEVELOPING AGENT

CROSS REFERENCE TO RELATED APPLICATION

This application claims priority from Japanese Patent Application No. 2013-137424 filed Jun. 28, 2013, the entire content of which is incorporated herein by reference.

TECHNICAL FIELD

The present invention relates to a developing device to be assembled in an electrophotographic type image forming device, and more particularly, to such device having a seal member.

BACKGROUND

A developing cartridge to be assembled in an electrophotographic type image forming device is well known. The developing cartridge includes a cartridge frame for accommodating therein developing agent (toner), a developing roller rotatably supported to the cartridge frame, and a seal member for restraining leakage of toner out of the cartridge frame.

Japanese Patent Application Publication No. 2011-150269 discloses a developing cartridge provided with seal members including a pair of side seals each positioned between each axial end portion of a developing roller and a developing frame, and a lower film extending over a length of the developing roller and between the developing roller and the developing frame. Each axial end portion of the lower film is in contact with each side seal.

With this structure, each side seal is adapted to restrain toner from leaking through a gap between each axial end portion of the developing roller and the developing frame, and the lower film is adapted to restrain toner from leaking through a gap between the lengthwise portion of the developing roller and the developing frame.

SUMMARY

In order to meet with a recent demand of high speed image formation, several requirements must be fulfilled such as high speed rotation of the developing roller, prolonged service life of the developing cartridge, and microparticulation of toner for the purpose of low temperature image fixing. To this effect, toner leakage through a boundary between the lower film and the side seal and through the gap between each axial end portion of the developing roller and the developing frame must further be prevented.

In view of the foregoing, it is an object of the invention to provide a developing device capable of restraining toner leakage out of the developing frame.

In order to attain the above and other objects, the invention provides a developing device including a frame, a developing roller, a first seal, and a second seal. The frame may be configured to accommodate developing agent therein. The developing roller may be rotatable in a rotational direction about an axis defining an axial direction relative to the frame. The developing roller may have a peripheral surface and an end portion in the axial direction. The first seal may be provided between the frame and the peripheral surface at the end portion of the developing roller. The first seal may have an upstream end portion in the rotational direction. The second seal may extend in the axial direction and is in contact with the peripheral surface. The second seal may have an end region in the axial direction. The end region may be positioned between the first seal and the peripheral surface at the end portion of the developing roller. The frame may include a seal placement portion at which the first seal is positioned, and a seal adhesion surface to which the second seal is adhered. The seal placement portion may have a stepped portion connected to the seal adhesion surface and positioned farther from the developing roller than the seal adhesion surface to the developing roller in a direction perpendicular to the axial direction. The seal adhesion surface may include a first surface and a second surface. The first surface may be connected to the first seal in the axial direction and be positioned inward of the first seal in the axial direction. The second surface may be positioned adjacent to and upstream of the upstream end portion of the first seal. The second seal may have a first end portion and a second end portion. The first end portion may be adhered to the seal adhesion surface and may have an end part in the axial direction adhered onto the first seal. The second end portion may be positioned opposite to the first end portion in the rotational direction and in contact with the peripheral surface of the developing roller. The first seal may be compressed in the seal placement portion by the second seal to abut on the stepped portion.

BRIEF DESCRIPTION OF THE DRAWINGS

In the drawings:

FIG. **1** is a cross-sectional view of a developing cartridge as an example of a developing device taken along a plane at a longitudinally center portion thereof according to one embodiment of the present invention;

FIG. **2** is a central cross-sectional view of an image forming device in which the developing cartridge shown in FIG. **1** is assembled;

FIG. **3** is a perspective view of the developing cartridge shown in FIG. **1** as viewed from a left rear side thereof;

FIG. **4**A is a perspective view of the developing cartridge shown in FIG. **1** as viewed from a left rear side thereof, and showing a state where a developing roller is removed from a developing frame;

FIG. **4**B is an enlarged perspective view of a portion bounded by a quadrangle of FIG. **4**A and particularly showing a side seal and a left end portion of a lower film;

FIG. **5**A is an enlarged perspective view of the portion shown in FIG. **4**B as viewed from a left rear side thereof and showing a state where the lower film is removed;

FIG. **5**B is an enlarged perspective view of a seal placement portion as viewed from a left rear side thereof and showing a state where the side seal is removed;

FIG. **6**A is a rear view of a left end portion of the developing cartridge shown in FIG. **3**;

FIG. **6**B is a cross-sectional view taken along the line A-A of FIG. **6**A;

FIG. **6**C is a cross-sectional view taken along the line B-B of FIG. **6**A; and

FIG. **7** is a view for description of assembly of the side seal with respect to the seal placement portion shown in FIG. **5**B.

DETAILED DESCRIPTION

1. Overall Structure of Developing Cartridge

As shown in FIG. **1**, a developing cartridge **1** as an example of a developing device includes a cartridge frame **2**, a developing roller **4**, a supply roller **5** and a blade **6** for regulating a thickness of a toner layer.

In the following description, a side of the developing cartridge **1** at which the developing roller **4** is positioned will be referred to as "rear side", and a side opposite to the rear side will be referred to as "front side". Further, rightward/leftward direction will be given provided that the developing cartridge **1** is viewed from its front side. More specifically, each drawing contains arrows showing front side, rear side, upper side, lower side, left side and right side. For example, in FIG. **1**, left side and right side of the drawing are the rear side and front side of the developing cartridge **1**, respectively, and near side and back side of the drawing sheet are left side and right side of the developing cartridge **1**, respectively. Here, leftward/rightward direction is an example of an axial direction, and upward/downward direction is an example of a direction perpendicular to the axial direction. Further, inward of leftward/rightward direction is a direction toward a widthwise center of the developing cartridge **1**, and outward of leftward/rightward direction is a direction away from the widthwise center.

The cartridge frame **2** extends in the leftward/rightward direction and is box shaped having a rear end portion open in frontward/rearward direction. The cartridge frame **2** has an internal space for accommodating therein toner as an example of a developing agent.

The developing roller **4** is positioned at a rear end portion of the cartridge frame **2** and is rotatably supported thereto. The developing roller **4** has an upper rear portion exposed to an outside. The developing roller **4** has a shaft **11** and a supply roller body **12** coaxially disposed over the shaft **11**.

The supply roller **5** is positioned frontward of and diagonally below the developing roller **4**, and has an upper rear portion in pressure contact with a lower front portion of the developing roller **4**. The supply roller **5** is rotatably supported to the cartridge frame **2**. The supply roller **5** has a supply roller shaft **13** and a supply roller body **14** coaxially disposed over the supply roller shaft **13**.

The blade **6** is positioned frontward of and diagonally above the developing roller **4**, and extends in vertical direction. The blade **6** is supported to the cartridge frame **2** and has a lower end portion in contact with a front upper end portion of the developing roller **4**.

2. Overall Structure of Printer

As shown in FIG. **2**, a printer **15** is an electrophotographic type monochromatic printer, and includes a main casing **16**, a process cartridge **17**, a scanner unit **18** and a fixing unit **19**.

The main casing **16** is generally box-shaped and includes a front cover **21**, a sheet supply tray **22**, and a discharge tray **23**. The main casing **16** has a front wall formed with an opening **20** for allowing the process cartridge **17** to pass therethrough.

The front cover **21** is plate shaped and generally L-shaped in side view. The front cover **21** has a lower end portion pivotally movably connected to the front wall for opening and closing the opening **20**.

The sheet supply tray **22** is positioned at a bottom portion of the main casing **16**, and is configured to accommodate a stack of sheets P. The discharge tray **23** is provided at an upper surface of the main casing **16**.

The process cartridge **17** is configured to be attached to and detached from the main casing **16** through the opening **20**, and includes a drum cartridge **24** and the developing cartridge **1**.

The drum cartridge **24** includes a photosensitive drum **25**, a scorotron charger **26**, and a transfer roller **27**. The photosensitive drum **25** is generally cylindrical, and positioned at a rear end portion of a frame of the drum cartridge **24**, and extends in the leftward/rightward direction. The photosensitive drum **25** is rotatably supported to the frame of the drum cartridge **24**. The scorotron charger **26** is positioned rearward of and spaced away from the photosensitive drum **25**. The transfer roller **27** is positioned below the photosensitive drum **25**, and in contact with a lower portion thereof.

The developing cartridge **1** is configured to be attached to and detached from the frame of the drum cartridge **24**. A rear end portion of the developing roller **4** is in contact with a front end portion of the photosensitive drum **25** when the developing cartridge **1** is attached to the frame of the drum cartridge **24**.

The scanner unit **18** is positioned above the process cartridge **17**, and is adapted to emit laser beam on the basis of image data to the photosensitive drum **25** as indicated by a broken line shown in FIG. **2**.

The fixing unit **19** is positioned rearward of the process cartridge **17**, and includes a heat roller **28** and a pressure roller **29** positioned diagonally below and rearward of the heat roller **28**. The pressure roller **29** is in pressure contact with a rear lower portion of the heat roller **28**.

In operation, upon start of an image forming operation controlled by a controller (not shown), the scorotron charger **26** uniformly charges a surface of the photosensitive drum **25**. Then, the scanner unit **18** exposes the photosensitive drum **25** to light, so that an electrostatic latent image based on the image data is formed on the surface of the photosensitive drum **25**.

The supply roller **5** supplies toner in the cartridge frame **2** to the developing roller **4**, such that the toner triboelectrically charged with positive polarity between the developing roller **4** and the supply roller **5** is carried on the developing roller **4**. The blade **6** regulates a thickness of a toner layer carried on the developing roller **4** into a uniform thickness.

The developing roller **4** supplies the toner to the electrostatic latent image formed on the surface of the photosensitive drum **25**, so that a visible toner image corresponding to the latent image is carried on the surface of the photosensitive drum **25**.

Each one of the sheets P is supplied at a prescribed timing to a portion between the photosensitive drum **25** and the transfer roller **27** by the rotation of conveyer rollers. Thus, the toner image carried on the photosensitive drum **25** is transferred onto the sheet P when the sheet P is moved past the portion between the photosensitive drum **25** and the transfer roller **27**.

Then, the sheet P carrying the toner image is heated and compressed when the sheet P is moved past a portion between the heat roller **28** and the pressure roller **29**. Thus, the toner image can be thermally fixed to the sheet P. The sheet P is then discharged onto the discharge tray **23**.

3. Details of Developing Cartridge

(1) Cartridge Frame

The developing cartridge **1** includes the cartridge frame **2** shown in FIGS. **1** and **3** as described above. The cartridge frame **2** includes a pair of side walls **35**, a lower wall **37**, a front wall **36**, and an upper wall **38**.

The side walls **35** are positioned at left end and right end portions of the cartridge frame **2**, respectively, and spaced away from each other as shown in FIG. **3**. As shown in FIG. **1**, each side wall **35** has a toner chamber wall portion **40** and a developing chamber wall portion **41** integrally therewith. The toner chamber wall portion **40** is located at a front portion of the side wall **35** and extends in frontward/rearward direction, and is generally rectangular plate shaped.

The developing chamber wall portion **41** is located at a rear portion of the side wall **35**, and extends rearward from a rear end portion of the toner chamber wall portion **40**. The developing chamber wall portion **41** is generally rectangular plate shaped. As shown in FIG. **4**B, the developing chamber wall

portion **41** is formed with a groove **42** for receiving the shaft **11** of the developing roller **4** and a through-hole **43** for allowing the supply roller shaft **13** of the supply roller **5** to pass therethrough.

The groove **42** is formed at a rear end portion of the developing chamber wall portion **41**, and is generally C-shaped in a side view opening rearward. The groove **42** is positioned at generally a center portion of the rear end portion of the developing chamber wall portion **41** in the vertical direction, and is recessed frontward. The groove **42** has an inner diameter that is greater than an outer diameter of the shaft **11** of the developing roller **4**.

The through-hole **43** is positioned diagonally front and downward of the groove **42**, and has a generally rectangular shaped in side view. The through-hole **43** is formed throughout a thickness of the developing chamber wall portion **41**. The through-hole **43** has an inside dimension greater than an outer diameter of the supply roller shaft **13** of the supply roller **5**.

As shown in FIG. **1**, the lower wall **37** is positioned at a lower end portion of the cartridge frame **2**, and includes a curved wall portion **48** and a semi-circular wall portion **49** integrally therewith. The curved wall portion **48** is arcuate and its central portion in the frontward/rearward direction is bent downward. The curved wall portion **48** extends in the leftward/rightward direction and its distal end is connected to and flush with each lower end portion of each toner chamber wall portion **40** of each side wall **35**.

The semi-circular wall portion **49** is positioned rearward of the curved wall portion **48**, and is semi-circular shaped in side view opening upward. The semi-circular wall portion **49** has an inner peripheral surface whose contour is in conformance with an outer peripheral surface of the supply roller **5**. The semi-circular wall portion **49** has a front end portion connected to a rear end portion of the curved wall portion **48**. The semi-circular wall portion **49** extends in the leftward/rightward direction and its each distal end is connected to and flush with each inner end portion in the leftward/rightward direction of each seal receiving portion **45** (FIG. **5**B, described later).

The front wall **36** is located at the front end portion of the cartridge frame **2**, and is generally rectangular plate shaped in front view. The front wall **36** is continuous with a front end portion of the curved wall portion **48** and extends upward therefrom. The front wall **36** has end portions in the leftward/rightward direction, each end portion being connected to and flush with the front end portion of the toner chamber wall portion **40** of the side wall **35**.

The upper wall **38** is located at the upper end portion of the cartridge frame **2**, and includes a cover portion **70** and a blade seal support portion **71**. The cover portion **70** is located at a front end portion of the upper wall **38** and is generally rectangular shaped in plan view. The cover portion **70** extends rearward from an upper end portion of the front wall **36**, and also extends in the leftward/rightward direction having each distal end connected to and flush with each upper end portion of each toner chamber wall portion **40** of each side wall **35**.

The blade seal support portion **71** is located at a rear end portion of the upper wall **38**, and is positioned rearward of the cover portion **70**. The blade seal support portion **71** is elongated plate shaped extending in the leftward/rightward direction and has a front end portion connected to a rear end portion of the cover portion **70**. Further, each end portion of the blade seal support portion **71** in the leftward/rightward direction is connected to each upper end portion of each developing chamber wall portion **41** of each side wall **35**.

As shown in FIGS. **1** and **4**A, the cartridge frame **2** also includes a seal placement portion **39** as an example of a placement portion, and an adhering portion **52** provided integrally therewith. The seal placement portion **39** is provided at each end portion in the leftward/rightward direction of the roller body **12** of the developing roller **4**. Further, each seal placement portion **39** is positioned inward of the developing chamber wall portion **41** in the leftward/rightward direction. As shown in FIG. **6**C, the seal placement portion **39** includes the seal receiving portion **45**, a first support portion **46**, and a second support portion **44**.

The seal receiving portion **45** is generally U-shaped in side view opening diagonally upward and rearward, and protrudes inward in the leftward/rightward direction from a portion surrounding the through-hole **43**. An innermost end of the seal receiving portion **45** in the leftward/rightward direction is connected to an end portion of the semi-circular wall portion **49** in the leftward/rightward direction.

The first support portion **46** extends upward from an upper end portion of a front wall of the seal receiving portion **45**. As shown in FIG. **5**B, the first support portion **46** extends in the leftward/rightward direction and has its distal ends each being connected to each inner surface in the leftward/rightward direction of the developing chamber wall portion **41**. As shown in FIG. **6**C, a rib **47** protrudes rearward from an upper rear surface of the first support portion **46**. The rib **47** extends in the leftward/rightward direction.

The second support portion **44** extends rearward from an upper end portion of a rear wall of the seal receiving portion **45**. As shown in FIG. **5**B, the second support portion **44** extends in the leftward/rightward direction and its distal end portion is connected to an inner surface in the leftward/rightward direction of the developing chamber wall portion **41**. The second support portion **44** is formed with a hole **55** positioned at a center portion thereof in plan view and generally rectangular shaped in plan view extending in frontward/rearward direction. As shown in FIG. **6**C, the hole **55** extends throughout a thickness of the second support portion **44**.

As shown in FIGS. **4**A and **4**B, the adhering portion **52** includes a lip portion **50**, a pair of extension portions **58** and a pair of protrusions **56**. As shown in FIG. **1**, the lip portion **50** is positioned rearward of the semi-circular wall portion **49**, and includes a base portion **61** and a hook portion **62** integral therewith. The base portion **61** extends diagonally downward and rearward from a rear end portion of the semi-circular wall portion **49**. As shown in FIG. **4**B, the base portion **61** has a rear end portion positioned rearward of a rear end portion of the second support portion **44**.

Further, the base portion **61** extends in the leftward/rightward direction, and its each distal end is connected to and flush with each inner end in the leftward/rightward direction of the second support portion **44** as shown in FIG. **5**B. Further, the base portion **61** has a vertical dimension greater than that of the second support portion **44**. Therefore, an upper surface of the base portion **61** is positioned higher than an upper surface of the second support portion **44**.

Thus, a regulation surface **66** as an example of a stepped portion is provided between the upper surface of the base portion **61** and the upper surface of the second support portion **44**. The regulation surface **66** is an end face in the leftward/rightward direction of the base portion **61**, so that an outer edge in the leftward/rightward direction of the upper surface of the base portion **61** is connected to the upper surface of the second support portion **44** through the regulation surface **66**.

As shown in FIG. **1**, the base portion **61** has a lip adhering surface **65** as an example of a first surface. The lip adhering

surface **65** is located at an upper rear end portion of the base portion **61**, and is inclined diagonally downward and rearward in side view. That is, the lip adhering surface **65** is continuous with a rear edge of the regulation surface **66** as shown in FIG. **5**B. The lip adhering surface **65** is positioned inward of a side seal **78** (described later) in the leftward/rightward direction.

As shown in FIG. **1**, the hook portion **62** is generally L-shaped in side view, and extends rearward from a rear end portion of the base portion **61**, and is then bent upward.

As shown in FIG. **5**B, each extension portion **58** is positioned outward in the leftward/rightward direction of the rear end portion of the base portion **61**, and is positioned rearward of the associated second support portion **44**, so that the pair of extension portions **58** interpose therebetween the base portion **61** in the leftward/rightward direction.

Each extension portion **58** is plate-shaped elongated in the leftward/rightward direction. An inner end portion in the leftward/rightward direction of the extension portion **58** is connected to an end portion in the leftward/rightward direction of the rear end portion of the base portion **61**. Further, a front end portion of the extension portion **58** is connected to an inner end in the leftward/rightward direction of the rear end portion of the second support portion **44**. That is, as shown in FIG. **6**B, the extension portion **58** protrudes rearward from the rear end portion of the second support portion **44**.

The extension portion **58** has an upper surface at which an extension portion adhering surface **59** as an example of a third surface is defined. The extension portion adhering surface **59** is inclined diagonally downward and rearward, and is continuous with an upper surface of the second support portion **44** corresponding to a recessed portion **67** described later. That is, the extension portion adhering surface **59** extends diagonally downward and rearward from the rear end portion of the upper surface of the second support portion **44**. Further, the extension portion adhering surface **59** is continuous with and flush with the lip adhering surface **65** in the leftward/rightward direction.

The protrusion **56** is provided on an upper surface of the second support portion **44** at a position rearward of the hole **55**, and is positioned frontward of the extension portion **58**.

As shown in FIG. **6**C, the protrusion **56** is generally trapezoidal in side view, and protrudes upward from the upper surface of the second support portion **44**. Further, the protrusion **56** has a protrusion adhering surface **57** as an example of a second surface. The protrusion adhering surface **57** is a rear surface of the protrusion **56** and is inclined diagonally downward rearward. Further, the protrusion adhering surface **57** and the extension portion adhering surface **59** are continuous with and flush with each other in the leftward/rightward direction as shown in FIG. **5**B. That is, flushing surface relationship is provided among the lip adhering surface **65**, the protrusion adhering surface **57** and the extension portion adhering surface **59**, and these are located on an imaginary identical plane.

The protrusion **56** is positioned outward of in the leftward/rightward direction and spaced away from a rear portion of the regulation surface **66**. Thus, the above-mentioned recessed portion **67** is defined by the rear end portion of the regulation surface **66**, inner surface in the leftward/rightward direction of the protrusion **56**, and the upper surface of the second support portion **44** positioned therebetween. The recessed portion **67** is an example of a grooved portion. The recessed portion **67** constitutes a part of the regulation surface **66**.

The recessed portion **67** is U-shaped in back view opening upward. The recessed portion **67** has the rear portion of the regulation surface **66**, and is recessed downward such that a bottom end of the recessed portion **67** is positioned farther from the developing roller **4** than the lip adhering surface **65** and the protrusion adhering surface **57** from the developing roller **4**.

Further, the recessed portion **67** is surrounded by the lip adhering surface **65**, the protrusion adhering surface **57**, and the extension portion adhering surface **59** in plan view. In other words, the lip adhering surface **65** and the protrusion adhering surface **57** are spaced away from each other in the leftward/rightward direction, and the extension portion adhering surface **59** is positioned downstream of the protrusion adhering surface **57** and the recessed portion **67** in a first direction X shown in FIG. **6**C and described later.

(2) Toner Chamber

A toner chamber **7** is defined at a front portion of the cartridge frame **2** as shown in FIG. **1**, and a developing chamber **8** is defined at the rear portion thereof. The toner chamber **7** and the developing chamber **8** are communicated with each other in frontward/rearward direction.

The toner chamber **7** is generally box shaped open rearward, and includes the pair of toner chamber wall portions **40**, the curved wall portion **48**, the front wall **36** and the cover portion **70**. The toner chamber **7** is adapted to accommodate therein positively chargeable non-magnetic single component type polymerized toner. Further, an agitator **3** is provided in the toner chamber **7**.

The agitator **3** is positioned at a center portion of the toner chamber **7** in side view, and includes an agitator shaft **9** and agitation blade **10**. The agitator shaft **9** is generally cylindrical and extends in the leftward/rightward direction. The agitation blade **10** extends radially outward from the agitator shaft **9**. The agitator **3** is supported to the cartridge frame **2** such that each axial end portion of the agitator shaft **9** is rotatably supported to each toner chamber wall portion **40**.

(3) Developing Chamber

The developing chamber **8** is defined by the pair of developing chamber wall portion **41**, the semi-circular wall portion **49**, the lip portion **50**, and the blade seal support portion **71**. The developing chamber **8** is provided with the developing roller **4**, the supply roller **5**, the blade **6**, and a seal unit **75**.

The developing roller **4** is positioned at a rear end portion of the developing chamber **8** and above the lip portion **50**. As shown in FIGS. **1** and **3**, the developing roller **4** includes the shaft **11** and the developing roller body **12**. The shaft **11** is made from metal and generally cylindrical extending in the leftward/rightward direction. Each left and right end portion of the shaft **11** is inserted through the groove **42** formed in the developing chamber wall portion **41**.

The developing roller body **12** is generally cylindrical and extends in the leftward/rightward direction. The developing roller body **12** is made from an electrically conductive rubber. The developing roller body **12** is formed over the shaft **11** except the left and right end portions thereof. The upper and rear portions of the developing roller body **12** are exposed to an outside of the cartridge frame **2**. Further, as shown in FIG. **6**C, each of the left and right end portions of the developing roller body **12** is positioned diagonally rearward and upward of the seal placement portion **39**. The developing roller **4** is supported to the cartridge frame **2** such that each of the left and right end portions of the shaft **11** is rotatably supported to the developing chamber wall portion **41**.

Incidentally, the developing roller **4** is configured to receive a driving force from a drive source such as a motor (not shown) during a developing operation. Further, the developing roller **4** is applied with a developing bias from a power source during a developing operation. Upon application of the driving force to the developing roller **4**, the developing roller **4** is rotated about a center axis A of the shaft **11** in a rotating direction R, i.e., clockwise direction in right side view. The center axis A is an example of a first axis. The drive source and power source are provided in the main casing **16**.

As shown in FIG. **1**, the supply roller **5** is positioned on the semi-circular wall portion **49**, and includes the supply roller shaft **13** and the supply roller body **14**. The supply roller shaft **13** is made from metal and generally cylindrical extending in the leftward/rightward direction. Each left and right end portion of the supply roller shaft **13** is inserted through the through-hole **43** formed in the developing chamber wall portion **41** as shown in FIG. **5**B.

The supply roller body **14** is generally cylindrical extending in the leftward/rightward direction, and made from an electrically conductive sponge. The supply roller body **14** is formed over the supply roller shaft **13** except the left and right end portions thereof. The upper rear portion of the supply roller body **14** is in contact with the lower front portion of the developing roller body **12**. The supply roller **5** is supported to the cartridge frame **2** such that each of the left and right end portions of the supply roller shaft **13** is rotatably supported to the developing chamber wall portion **41**.

Incidentally, the supply roller **5** is configured to receive a driving force from the drive source such as the motor (not shown) during a developing operation. Further, the supply roller **5** is applied with a supply bias from the power source during a developing operation. Upon application of a driving force to the supply roller **5**, the supply roller **5** is rotated in a rotating direction opposite to the rotating direction of the developing roller **4**, i.e., counterclockwise direction in a left side view in FIG. **1** at a portion contacting the developing roller **4**.

As shown in FIG. **1**, the blade **6** is positioned rearward of the blade seal support portion **71**, and is elongated rectangular shaped extending in the leftward/rightward direction as shown in FIG. **3**. The blade **6** is made from a thin metal plate resiliently deformable. The blade **6** is fixed to the blade seal support portion **71** such that a lower end of the blade **6** is in contact with a front end portion of the developing roller body **12** as shown in FIG. **1** over the length of the blade **6**.

The seal unit **75** includes a blade seal **76**, a supply seal **77**, the side seal **78** as an example of a first seal and a lower film **79** as an example of a second seal as shown in FIGS. **1**, **4**A, and **6**B. The blade seal **76** is interposed between a front surface of the blade **6** and a rear surface of the blade seal support portion **71** as shown in FIG. **1**. The blade seal **76** is made from a resiliently deformable material such as a sponge. The blade seal **76** is elongate plate shaped extending in the leftward/rightward direction as shown in FIG. **4**A.

The supply seal **77** is provided at each axial end portion of the supply roller shaft **13**, and is accommodated in the seal receiving portion **45** as shown in FIG. **6**C. The supply seal **77** is made from a resiliently deformable material such as a sponge, and is generally rectangular shaped in side view extending in the leftward/rightward direction.

The supply seal **77** is formed with a shaft insertion hole **80** at a central portion thereof in side view. The shaft insertion hole **80** extends throughout the supply seal **77** in the leftward/rightward direction. Each of the left and right end portions of the supply roller shaft **13** is rotatably received in each shaft insertion hole **80**. Thus, each supply seal **77** is positioned outward in the leftward/rightward direction of each end face of the supply roller body **14**.

The supply seal **77** has a rear surface formed into an arcuate shape in side view, in conformance with a curvature of the peripheral surface of the developing roller body **12**. The rear surface of the supply seal **77** is continuous with a rear surface of the first support portion **46** and an upper surface of the second support portion **44** as shown in FIG. **6**C.

As shown in FIG. **4**A each side seal **78** is provided at each seal placement portion **39**. As shown in FIG. **6**C, the side seal **78** is provided between the seal placement portion **39** and the peripheral surface of the axial end portion of the developing roller body **12**.

The side seal **78** includes a base portion **85** and a contact portion **86**. The base portion **85** is made from a resiliently deformable material such as a sponge and an elastomer, for example, silicone rubber and natural rubber. The base portion **85** includes a main seal portion **88** and a projecting portion **87**.

The main seal portion **88** is generally prismatic body shaped extending in a vertical direction as shown in FIG. **7**. The projecting portion **87** is located at a lower end portion of the main seal portion **88**. The projecting portion **87** is generally prismatic body shaped and protruding downward from an inner end portion in the leftward/rightward direction of a lower surface of the main seal portion **88**.

The projecting portion **87** has a dimension L**2** in the leftward/rightward direction less than or equal to half the length of a dimension L**3** in the leftward/rightward direction of the main seal portion **88** in a state prior to the placement of the side seal **78** on the seal placement portion **39**, and more specifically, the dimension L**2** is approximately one fourth of the dimension L**3**. Further, the dimension L**2** is more than or equal to a dimension L**1** in the leftward/rightward direction of the recessed portion **67**, i.e., L**1** is a distance between the regulation surface **66** and the inner surface in the leftward/rightward direction of the protrusion **56** in a state prior to the placement of the side seal **78** on the seal placement portion **39**, and more specifically, L**2** is greater than L**1**.

The contact portion **86** is positioned adjacent to and rearward of the main seal portion **88**. The contact portion **86** is made of a fabric material or felt material of, for example, cashmere fiber, polytetrafluoroethylene (PTFE) fiber, and polyester fiber. The contact portion **86** has a shape and dimension identical to those of the main seal portion **88** in rear view, and is adhesively bonded to a rear surface of the main seal portion **88**.

As shown in FIG. **6**C, the side seal **78** is curved into C-shape opening rearward and upward, and is placed on the seal placement portion **39**. As shown in FIG. **5**A, a center portion in the leftward/rightward direction of an upstream end in the rotational direction R of the main seal portion **88** is in contact with a front end surface of the protrusion **56** in a state where the side seal **78** is positioned on the seal placement portion **39**. With this structure, the protrusion **56** prevents the side seal **78** from moving in a direction opposite to the rotational direction R.

The main seal portion **88** has a downstream end in the rotational direction R in contact with the lower surface of the rib **47**. With this structure, the rib **47** prevents the side seal **78** from moving in the rotational direction R. Consequently, the protrusion **56** and the rib **47** provide positioning of the side seal **78** in the rotational direction R.

Further, as shown in FIGS. **5**A and **6**B, the projecting portion **87** is positioned in the recessed portion **67**. Therefore, in plan view, the base portion **61** is positioned immediate rightward of the projecting portion **87**, the protrusion **56** is

positioned immediate leftward of the projecting portion **87**, and the extension portion **58** is positioned rearward of the projecting portion **87**, that is upstream of the projecting portion **87** in the rotational direction R. Further, the projecting portion **87** is positioned at the most upstream position of the side seal **78** in the rotational direction R. The projecting portion **87** is positioned upstream of the main seal portion **88** and protrudes toward and upstream in the rotational direction R from the main seal portion **88**.

The lower film **79** is positioned on an upper surface of the lip portion **50** as shown in FIG. **1**. The lower film **79** is made from a resin sheet such as polyethylene terephthalate, and is rectangular shaped extending in the leftward/rightward direction in plan view.

As shown in FIG. **4**B, the lower film **79** has an adhesive layer **89** such as a double-stick tape. The adhesive layer **89** is positioned at a lower surface of a rear end portion **94** of the lower film **79** and extends over a length of the lower film **79** in the leftward/rightward direction. The rear end portion **94** is an example of a first end portion.

As shown in FIGS. **4**A and **4**B, the lower film **79** is supported by the cartridge frame **2** in such a manner that the adhesive layer **89** is collectively adhered on the upper surfaces of the lip adhering surface **65**, the extension portion adhering surface **59**, the protrusion adhering surface **57**, and the projecting portion **87**. That is, the rear end portion **94** of the lower film **79** is adhered to the adhering portion **52** through the adhesive layer **89**, more specifically to the lip adhering surface **65**, the extension portion adhering surface **59**, and the protrusion adhering surface **57**. Thus, the lip adhering surface **65**, the extension portion adhering surface **59**, and the protrusion adhering surface **57** function as an adhesion surface.

As shown in FIG. **6**C, the lower film **79** has a front end portion **95** in contact with a lower peripheral end portion of the developing roller body **12** along a length thereof in the leftward/rightward direction. The front end portion **95** is an example of a second end portion. In side view, the lower film **79** extends from the front end portion **95** to the rear end portion **94** in a first direction X directed diagonally downward and rearward from the front end portion **95**.

Further, each of left and right end regions of the front end portion **95** of the lower film **79** is nipped between an upstream end portion in the rotational direction R of the contact portion **86** of the side seal **78** and a peripheral surface of the developing roller body **12**. In other words, the end region of the lower film **79** is positioned between the side seal **78** and the peripheral surface at the end portion of the developing roller **4**.

Further, as shown in FIG. **6**B, a space S is defined at an upstream end portion of the projecting portion **87** in the rotational direction by an upstream end surface of the projecting portion **87** in the rotational direction R, the recessed portion **67**, and a lower surface of the rear end portion **94** of the lower film **79**. More specifically, the space S is defined by the upstream end surface of the projecting portion **87**, inner surface in the leftward/rightward direction of the protrusion **56**, the regulation surface **66**, the upper surface of the second support portion **44**, and the lower surface of the rear end portion **94** of the lower film **79**.

(4) Attachment of Side Seal and Lower Film to the Cartridge Frame

The side seal **78** and the lower film **79** are attached to the cartridge frame **2** in the following manner:

First, as shown in FIG. **7**, the side seal **78** is attached to the seal placement portion **39**. To this effect, the side seal **78** is initially positioned rearward of the seal placement portion **39**, and then gradually approaches the seal placement portion **39**.

In this case, as shown in FIG. **6**C, the side seal **78** is resiliently deformed into C-shape in side view such that the upper end of the main seal portion **88** is in contact with the lower surface of the rib **47**, and the lower end of the main seal portion **88** is in contact with the front surface of the protrusion **56**.

Further, since the dimension L**2** in the leftward/rightward direction of the projecting portion **87** is greater than the dimension L**1** in the leftward/rightward direction of the recessed portion **67**, the projecting portion **87** is forced into the recessed portion **67** in a compressed manner in the leftward/rightward direction. Therefore, the projecting portion **87** is nipped between the regulation surface **66** and the inner surface in the leftward/rightward direction of the protrusion **56**, and is compressed in the leftward/rightward direction.

In this case, the protrusion **56** is positioned immediate leftward of the projecting portion **87**, and immediate upstream in the rotational direction R of the main seal portion **88**. Further, the base portion **61** is positioned opposite to the protrusion **56** with respect to the projecting portion **87**, and is positioned rightward of the projecting portion **87**. As a result, attachment of the side seal **78** to the seal placement portion **39** is completed. In a state where the side seal **78** is attached to the seal placement portion **39**, the front surface of the main seal portion **88** (the front surface being the surface facing the seal placement portion **39**) is in direct contact with the rear surface of the first support portion **46**, the rear surface of the supply seal **77**, and the upper surface with the second support portion **44** as shown in FIG. **6**C.

Then, as shown in FIGS. **4**A and **4**B, the lower film **79** is attached to the lip portion **50** from above, so that the center portion in the leftward/rightward direction of the adhesive layer **89** of the lower film **79** is adhered to the lip adhering surface **65**, and left and right end portions of the adhesive layer **89** are adhered to the extension portion adhering surface **59**, the protrusion adhering surface **57** and the upper surface of the projecting portion **87**.

Thus, as shown in FIG. **6**B, the projecting portion **87** is positioned between the end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** and a bottom surface of the recessed portion **67**. Further, the projecting portion **87** is compressed from the above by the lower film **79**. Accordingly, the projecting portion **87** is in close contact with the regulation surface **66** (FIG. **5**B), the inner surface in the leftward/rightward direction of the protrusion **56** and the upper surface of the second support portion **44** as shown in FIG. **4**B. With this structure, attachment of the lower film **79** to the lip portion **50** is completed.

Next, the developing roller **4** is assembled to the developing chamber **8** of the cartridge frame **2**. By this assembly, the lower peripheral end portion of the developing roller body **12** is in contact with the front end portion **95** of the lower film **79** throughout the length of the developing roller body **12** in the leftward/rightward direction as shown in FIG. **1**.

Further, each end portion in the leftward/rightward direction of the developing roller body **12** is positioned diagonally upward and rearward of the side seal **78** such that the side seal **78** is interposed between the end portion of the developing roller body **12** and the seal placement portion **39**. Further, each end portion in the leftward/rightward direction of the front end portion **95** of the lower film **79** is interposed between the upstream end portion in the rotational direction R of the contact portion **86** of the side seal **78** and the peripheral surface at the end portion in the leftward/rightward direction of the developing roller body **12**.

Here, the upstream end portion in rotational direction R of the side seal **78** is nipped and compressed in the vertical direction between the end portion in the leftward/rightward direction of the developing roller body **12** and the second support portion **44**. Accordingly, the upstream end portion in rotational direction R of the main seal portion **88** is bulged downward into the hole **55**. As a result, resilient force of the main seal portion **88** is lowered. Consequently, excessive compression to the end portion in the leftward/rightward direction of the front end portion **95** of the lower film **79** against the peripheral surface of the developing roller body **12** due to the resilient force of the main seal portion **88** can be restrained. As a result, frictional wearing of the developing roller body **12** and the end portion in the leftward/rightward direction of the front end portion **95** of the lower film **79** can be restrained.

(5) Developing Operation

The developing cartridge **1** performs a developing operation as follows. The developing roller **4**, the supply roller **5** and the agitator **3** are rotated upon receiving driving force from the drive source (not shown) as shown in FIG. **1**. The agitation blade **10** conveys the toner in the toner chamber **7** toward the developing chamber **8** by the rotation of the agitator **3**, so that the toner is supplied from the toner chamber **7** to the developing chamber **8**.

The toner supplied to the developing chamber **8** is then supplied to the supply roller body **14** of the supply roller **5**, so that the toner is supplied from the supply roller body **14** to the developing roller body **12** of the developing roller **4** by the rotation of the supply roller **5**. In this case, triboelectric charging occurs for charging the toner with positive polarity. Thus, the developing roller body **12** carries the toner.

Then, the toner layer thickness regulation blade **6** regulates a thickness of the toner layer carried on the surface of the developing roller body **12**. In this case, since the contact portion **86** of the side seal **78** is in contact with the peripheral surface of the end portion in the leftward/rightward direction of the developing roller body **12** as shown in FIG. **6**C, toner leakage out of the end portion in the leftward/rightward direction of the developing roller **4** can be restrained.

Further, since the projecting portion **87** is compressed in the recessed portion **67** as shown in FIG. **4**B, toner leakage out of a boundary between the recessed portion **67** and the projecting portion **87** can be restrained. Further, since the rear end portion **94** of the lower film **79** is adhesively attached to the upper surface of the projecting portion **87**, the toner which may be moved along a surface of the side seal **78** can be dammed up by the rear end portion **94** of the lower film **79**.

3. Function and Effect

(1) As shown in FIG. **5**A, the developing cartridge **1** is provided with the lip adhering surface **65** positioned immediately rightward of the side seal **78**, and the protrusion adhering surface **57** positioned immediately rearward of the side seal **78** in plan view. Further, as shown in FIG. **4**B, each end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** is adhered to the lip adhering surface **65** and the protrusion adhering surface **57**. With this structure, the side seal **78**, in particular the projecting portion **87** positioned immediately beside the lip adhering surface **65** and the protrusion adhering surface **57** is compressed by the rear end portion **94** of the lower film **79** in the seal placement portion **39**.

Accordingly, intimate contact between the side seal **78** and the lower film **79** can result, and intimate contact between the projecting portion **87** of the side seal **78** and the regulation surface **66** of the recessed portion **67** can result. Consequently, generation of a gap at the boundary between the side seal **78** and the lower film **79** and at the boundary between the projecting portion **87** and the regulation surface **66** can be restrained. As a result, toner leakage from the boundary between the side seal **78** and the lower film **79** and the boundary between the projecting portion **87** and the regulation surface **66** can be restrained.

At least a part of the rear end portion **94** of the lower film **79** is adhered to the projecting portion **87** of the side seal **78**. Therefore, toner leaking along the surface of the side seal **78** can be blocked or dammed up by the rear end portion **94**. Consequently, toner leakage through a gap between the side seal **78** and the peripheral surface of the end portion in the leftward/rightward direction of the developing roller **4** can be restrained.

As a result, toner leakage out of the cartridge frame **2** can be restrained even by the high speed operation of the developing roller **4**, prolongation of the service life of the developing cartridge **1**, and particle size reduction of the toner.

(2) As shown in FIG. **4**B, the adhering portion **52** includes the extension portion adhering surface **59**. Therefore, sufficient adhesion area for adhesively bonding the rear end portion **94** of the lower film **79** can be provided.

Further, since each end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** is adhered to the protrusion adhering surface **57**, the extension portion adhering surface **59**, and the lip adhering surface **65**, the stable compression to the projecting portion **87** by the end portion of the rear end portion **94** of the lower film **79** can be realized, so that stable contact of the projecting portion **87** with the regulation surface **66** of the recessed portion **67** can be realized.

(3) Further, the space S is defined by the upstream end portion in rotational direction R of the projecting portion **87**, the recessed portion **67**, and the lower surface of the rear end portion **94** of the lower film **79** as shown in FIG. **6**B. Therefore, even if toner is entered into the boundary between the projecting portion **87** and the regulation surface **66** in accordance with the rotation of the developing roller **4**, the entered toner can be retained in the space S. Thus, toner leakage out of the cartridge frame **2** can be restrained with certainty.

(4) Further, as shown in FIG. **6**B, the projecting portion **87** is positioned in the recessed portion **67**, so that each projecting portion **87** is compressed by each end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79**. That is, reaction force applied to the end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** can be lowered in comparison with a case where the main seal portion **88** is compressed by the end portion of the rear end portion **94**. Accordingly, peel off of the rear end portion **94** of the lower film **79** from the protrusion adhering surface **57**, the extension portion adhering surface **59**, and the lip adhering surface **65** can be avoided or restrained.

(5) Further, as shown in FIG. **7**, prior to the placement of the side seal **78** to the seal placement portion **39**, the dimension L**2** in the leftward/rightward direction of the projecting portion **87** is more than or equal to the dimension L**1** in the leftward/rightward direction of the recessed portion **67**, L**1** being the distance in the leftward/rightward direction between the inner surface in the leftward/rightward direction of the protrusion **56** and the regulation surface **66**.

With this structure, stabilized compression to the projecting portion **87** can be provided in a state where the projecting portion **87** is positioned between the inner surface in the leftward/rightward direction of the protrusion **56** and the regulation surface **66**, and between the recessed portion **67** and the end portion in the leftward/rightward direction of the

rear end portion **94** of the lower film **79**. Accordingly, stable contact of the projecting portion **87** with the inner surface of the protrusion **56** and the regulation surface **66** can be provided. Consequently, generation of gap at the boundary between the projecting portion **87** and the inner surface in the leftward/rightward direction of the protrusion **57** and at the boundary between the projecting portion **87** and the regulation surface **66** can be restrained, thereby restraining toner leakage from these boundaries.

(6) Further, as shown in FIG. **7**, the dimension L**2** in the leftward/rightward direction of the projecting portion **87** is less than or equal to half of the dimension L**3** in the leftward/rightward direction of the main seal portion **88**, and more specifically, L**2** is approximately one-fourth of the dimension L**3** prior to attachment of the side seal **78** to the seal placement portion **39**.

With this structure, a volume of the base portion **85** to be compressed by the end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** can be reduced. Accordingly, reaction force applied to the end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** can be reduced, thereby preventing the rear end portion **94** of the lower film **79** from being peeled off from the adhering portion.

(7) Further, the end portion in the leftward/rightward direction of the rear end portion **94** of the lower film **79** is adhered to the protrusion adhering surface **57**, and the front surface of the protrusion **56** is in contact with the upstream end portion in rotational direction R of the main seal portion **88** of the side seal **78** as shown in FIG. **6**C.

That is, the protrusion **56** is used not only for adhering the end portion of the rear end portion **94** but also for positioning the side seal **78**. Accordingly, a compact developing cartridge **1** can be provided in comparison with a case where an adhesive portion to which the rear end portion **94** is adhered and a positioning portion for positioning the side seal **78** are provided independent of each other.

Accordingly, sufficient adhesion area for adhering the rear end portion **94** can be obtained, and a compact developing cartridge **1** can be provided while the positioning of the side seal **78** in rotational direction R is realized.

Further, the side seal **78** is in direct contact with the rear surface of the first support portion **46** and the upper surface of the second support portion **44** as shown in FIGS. **6**B and **6**C. That is, the side seal **78** is positioned in the seal placement portion **39** without adhesive bonding to the first support portion **46** and the second support portion **44**. Therefore, an additional member such as an adhesion tape for adhering the side seal **78** to the seal placement portion **39** can be dispensed with, thereby reducing a-cost. Further, attachment work for attaching the side seal **78** to the seal placement portion **39** can be facilitated because the adhesive tape is not employed.

4. Modification

While the invention has been described in detail with reference to the embodiment thereof, it would be apparent to those skilled in the art that various changes and modifications may be made therein without departing from the spirit of the invention.

For example, a developing cartridge can be integral with a drum cartridge. In the latter case, the integral process cartridge is an example of the developing device.

Further, a toner cartridge can be attached to and detached from a frame supporting the developing roller **4**. In other words, the toner cartridge can be detachably attached to a developing cartridge. In the latter case, the effect and function the same as those of the above-described embodiment can be obtained.

Further, the above-described embodiment and the modified embodiment can be suitably combined together.

What is claimed is:

1. A developing device comprising:

a frame configured to accommodate developing agent therein;

a developing roller rotatable in a rotational direction about an axis defining an axial direction relative to the frame, the developing roller having a peripheral surface and an end portion in the axial direction;

a first seal provided between the frame and the peripheral surface at the end portion of the developing roller, the first seal having an upstream end portion in the rotational direction; and

a second seal extending in the axial direction and in contact with the peripheral surface, the second seal having an end region in the axial direction, the end region being positioned between the first seal and the peripheral surface at the end portion of the developing roller;

wherein the frame comprises a seal placement portion at which the first seal is positioned, and a seal adhesion surface to which the second seal is adhered, the seal placement portion having a stepped portion connected to the seal adhesion surface and positioned farther from the developing roller than the seal adhesion surface to the developing roller in a direction perpendicular to the axial direction, the seal adhesion surface including a first surface and a second surface, the first surface being connected to the first seal in the axial direction and positioned inward of the first seal in the axial direction, and the second surface being positioned adjacent to and upstream of the upstream end portion of the first seal; and

wherein the second seal has a first end portion and a second end portion, the first end portion being adhered to the seal adhesion surface and having an end part in the axial direction adhered onto the first seal, the second end portion being positioned opposite to the first end portion in the rotational direction and in contact with the peripheral surface of the developing roller, the first seal being compressed in the seal placement portion by the second seal to abut on the stepped portion.

2. The developing device as claimed in claim **1**, wherein the first surface and the second surface are spaced away from each other in the axial direction;

wherein the seal placement portion has a grooved portion whose bottom is positioned farther from the developing roller than the seal adhesion surface to the developing roller, the grooved portion constituting a part of the stepped portion; and

wherein the seal adhesion surface further includes a third surface positioned downstream of the second surface and the grooved portion in the rotational direction.

3. The developing device as claimed in claim **2**, wherein the upstream end portion of the first seal, the grooved portion, and the second seal define a space.

4. The developing device as claimed in claim **2**, wherein the first seal has a main seal portion and a projecting portion protruding upstream in the rotational direction from the main seal portion and positioned in the grooved portion, the end part of the first end portion being adhered to the projecting portion.

5. The developing device as claimed in claim **4**, wherein the projecting portion has a dimension in the axial direction more than or equal to a dimension of the grooved portion in the axial direction prior to placement of the first seal in the seal placement portion.

6. The developing device as claimed in claim 4, wherein the projecting portion has a dimension in the axial direction less than or equal to a half of a dimension of the main seal portion in the axial direction.

7. The developing device as claimed in claim 1, wherein the frame further comprises a protrusion in abutment with the upstream end portion of the first seal for positioning the first seal in the rotational direction, the protrusion providing the second surface.

8. The developing device as claimed in claim 1, wherein the first seal is in direct contact with the frame.

* * * * *